

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings of claims in the application:

**Listing of Claims:**

Claim 1 (currently amended): A method of molding a part, comprising:

- preparing a base mold;
- placing a layer of fiberglass in the base mold;
- forming a closed mold by sealing a soft tool to the base mold over the layer of fiberglass, wherein a vacuum channel is defined between the soft tool and the base mold;
- applying a vacuum to the vacuum channel at a vacuum port thus creating a vacuum within the mold;
- injecting a resin into the mold to infuse the fiberglass layer with resin;
- curing the resin infused fiberglass to form a part;
- wherein said injecting is conducted using an injection head for ejecting a flowable substance, comprising:
  - a housing including a chamber defined within at least a portion of the housing, the chamber having a supply port, a purge port, and an outlet;
  - an actuator connected to the housing; and
  - an injection spindle connected to the ~~actuator~~ actuator and slidably retained within the chamber between an ejection position and a deployed position.

Claims 2-9 (canceled).

Claim 10 (previously amended): The method of claim 1, wherein said soft tool is adapted for use in a closed mold, said soft tool comprising:

- a sheet having an outer edge;
- a seal formed at the outer edge configured for sealing engagement with a base mold;

a vacuum channel formed at the outer edge and spaced inwardly of the seal, the vacuum channel being defined by at least one wall spaced inwardly of the seal; and

at least one injection port disposed in the sheet.

Claims 11-20 (canceled).

Claim 21 (currently amended): An injection head for ejecting a flowable substance, comprising:

a housing including a chamber defined within at least a portion of the housing, the chamber having a supply port, a purge port, and an outlet;

an actuator connected to the housing; and

an injection spindle connected to the ~~actua~~-or actuator and slidably retained within the chamber between an ejection position and a deployed position.

Claim 22 (original): The injection head of claim 21, further comprising a fastener disposed at the outlet of the chamber.

Claim 23 (original): The injection head of claim 22, wherein the fastener includes a threaded collar.

Claim 24 (currently amended): The injection head of claim 22, wherein the fastener includes a ~~locking~~ locking groove and flange.

Claim 25 (original): The injection head of claim 21, further comprising a tube retained within the chamber in the housing, wherein the tube is formed of low friction material.

Claim 26 (original): The injection head of claim 21, wherein the actuator includes a solenoid is disposed at one end of the housing opposed to the outlet, the supply port is disposed adjacent the outlet, and the purge port is disposed between the supply port and the solenoid.

Claim 27 (original): The injection head of claim 21, wherein the supply port is disposed between the purge port and the outlet.

Claim 28 (original): The injection head of claim 21, wherein the injection spindle has a variable cross-section to form passages between the chamber and the spindle.

Claim 29 (original): The injection head of claim 21, further comprising a removable plug releasably retained within the chamber.

Claim 30 (original): The injection head of claim 29, wherein the removable plug is disposed at an end of the injection spindle when the injection spindle is in the ejection position.

Claim 31 (original): The injection head of claim 30, wherein the injection spindle has an end shaped to complement the removable plug.

Claim 32 (original): The injection head of claim 30, wherein the plug is slidably retained within the chamber and is positioned at the outlet when the injection spindle is in the deployed position.

Claim 33 (original): The injection head of claim 29, wherein the removable plug is a sphere.

Claim 34 (original): The injection head of claim 29, wherein the removable plug is a disk shaped object.

Claim 35 (original): The injection head of claim 21, further comprising a seal disposed at the outlet of the chamber.

Claim 36 (currently amended): The injection head of claim 21, further comprising a tube retained within the chamber having an corresponding supply port and purge port, wherein the tube includes a edge at the outlet with an engaging formation and a ~~seal~~ seal retained within the engaging formation.

Claim 37 (original): The injection head of claim 21, wherein the injection spindle has a low friction surface.

Claim 38 (original): A molding system comprising:

a base mold;

a soft tool formed as a sheet having an outer edge, a seal formed at the outer edge and connected in sealing engagement with a base mold to form a closed mold, a vacuum channel formed at the outer edge of the sheet and spaced inwardly of the seal, and at least one injection port disposed in the sheet; and an injection head releasably connected to the injection port for injecting a flowable substance into the closed mold, including a housing with a chamber defined therein having a supply port, a purge port, and an outlet, an actuator connected to the housing, and an injection spindle connected to the actuator and slidably retained within the chamber between an ejection position and a deployed position.